

6061 .625 X.045W

7

**Work Order ID 81965****\*81965\***

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Page 1

Item ID: D2743

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Crossbolt Spacer

Stop **\*NS2\***

Start Date: 21/03/2012 Start Qty: 200.00

**\*200\***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 200.00

**\*200\***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/03/21 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2743

Rev B

100

0.00

**\*100\***

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA202 &amp; DWG D2743

FOLIO REV: 4ADWG REV: B

2-DEBURR AS REQUIRED

OK 12/03/24

210

110

0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK 12/03/24

210

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81965

**\*81965\***

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March-21-12 1:49:59 PM

Item ID: D2743 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Crossbolt Spacer  
Start Date: 21/03/2012 Start Qty: 200.00 **\*200\*** Cust Item ID:  
Required Date: 04/04/2012 Req'd Qty: 200.00 **\*200\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		52 12/03/08					
130 <b>*130*</b> Skidtubes Skidtubes	Memo 1- Clean crossbolt spacer with ultra bright aluminum cleaner	0.00  0.00		att 12-03-30				210	
160 <b>*160*</b> Packaging Packaging	Identify as per dwg & Stock Location: LG  Memo ***STOCK IN SKIDTUBE CELL***	0.00  0.00		AB 12-03-30					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*81965\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**\*200\***

**\*200\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

0.00

## Quality Control

442-04-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 81965

\*81965\*

Parent Item: D2743

\*D2743\*

Parent Item Name: Crossbolt Spacer

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP E05.04.13Reformat; removed tumble and deburr stepKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.625W.065		Purchased	No			100	f	113.0680	0.2667	56.14737			

\*M6061T6T0 625W 065\*

\*\*

6061-T6 RD Tube .625 x.065W

Location

Loc Qty

Loc Code

MAT014

113.068

117598

2.251

119678

2.817

120633

108

2.817  
56

OK 12/03/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

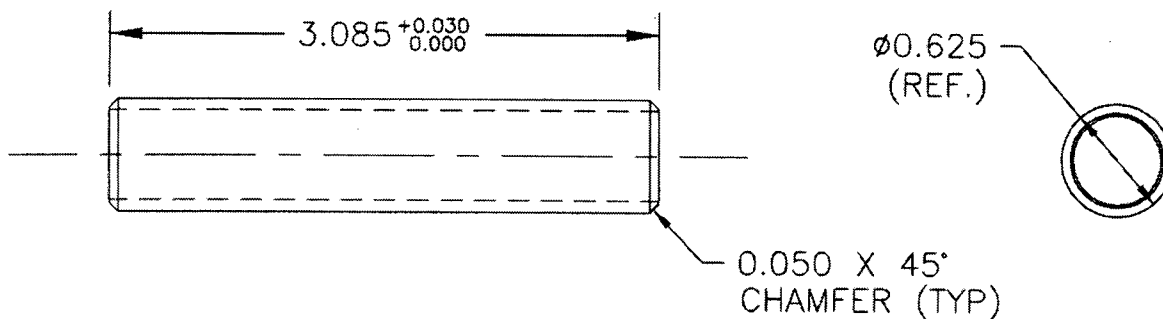






DESIGN <i>HA</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>HA</i>	APPROVED <i>KE</i>	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER SCALE 1:1	
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

RELEASED  
98.12.16 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81965 MCT  
12/03/21

MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED